

CLAIM AMENDMENTS:

1. (currently amended) A bent pipe element made of metal for bent pipe sections and for return pipes in internal combustion automobile engines, the pipe element comprising:

a first set of undulations having a first outer diameter; and
a second set of undulations having a second outer diameter which is less than said first outer diameter, said first and said second sets of undulations being disposed one behind the other in a longitudinal extension of the pipe element, wherein said second set of undulations is interposed between neighboring pairs of said first set of undulations and said first set of undulations is interposed between neighboring pairs of said second set of undulations, wherein, in an unbent state of the pipe element, each one of said first set of undulations extends through a convex, substantially circular first arc and joins a first straight segment extending substantially transverse to said longitudinal extension of the pipe element, said first straight segment joining a concave, substantially circular second arc, said second arc joining a second segment, said second segment joining onto a neighboring one of said second set of undulations, said neighboring one of said second set of undulations extending through a convex, substantially circular third arc, said third arc joining a third segment, said third segment joining a concave, substantially circular fourth arc, said fourth arc joining a fourth straight segment extending substantially parallel to said first straight segment, said fourth straight segment joining a neighboring one of said first set of undulations having said first

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arc, wherein said first arc, said second arc, said third arc, and said fourth arc have substantially equal radii of curvature, wherein said first outer diameter of said first set of undulations exceeds said second outer diameter of said second set of undulations by 5 to 20%, relative to said second outer diameter, the pipe element having a preset bending angle α which is always less than 140° .

2. (cancelled)
3. (original) The pipe element of claim 1, wherein said first outer diameter exceeds said second outer diameter by 10% to 15%, relative to said second outer diameter.
4. (cancelled)
5. (cancelled)
6. (cancelled)
7. (previously presented) The pipe element of claim 1, wherein, in the unbent pipe element, an inner radius and an outer radius of said first and said second set of undulations describe circular arcs of between 175° to 230° .
8. (previously presented) The pipe element of claim 7, wherein, in the unbent pipe element, an inner radius and an outer radius of said first and said second set of undulations describe a circular arc of approximately 180° .

9. (cancelled)
10. (original) The pipe element of claim 1, further comprising substantially cylindrical, non-undulated connecting ends.
11. (original) The pipe element of claim 10, wherein an average outer diameter of said first and said second sets of undulations exceeds an outer diameter of said connecting ends by 10% to 35%, relative to said outer diameter of said connecting ends.
12. (original) The pipe element of claim 1, wherein said first and said second sets of undulations are fashioned from a wall thickness of between 0.2mm and 0.5mm.
13. (original) The pipe element of claim 1, wherein said first and said second sets of undulations are fashioned from a wall thickness of approximately 0.4mm.
14. (cancelled)
15. (cancelled)
16. (previously presented) The pipe element of claim 25, wherein said first outer diameter exceeds said second outer diameter by 10% to 15%, relative to said second outer diameter.
17. (cancelled)
18. (cancelled)

19. (cancelled)
20. (cancelled).
21. (previously presented) The pipe element of claim 25, further comprising substantially cylindrical, non-undulated connecting ends.
22. (previously presented) The pipe element of claim 21, wherein an average outer diameter of said first and said second sets of undulations exceeds an outer diameter of said connecting ends by 10% to 35%, relative to said outer diameter of said connecting ends.
23. (previously presented) The pipe element of claim 25, wherein said first and said second sets of undulations are fashioned from a wall thickness of between 0.2mm and 0.5mm.
24. (previously presented) The pipe element of claim 25, wherein said first and said second sets of undulations are fashioned from a wall thickness of approximately 0.4mm.
25. (currently amended) A bent pipe element made of metal for bent pipe sections and for return pipes in internal combustion automobile engines, the pipe element comprising:
 - a first set of undulations having a first outer diameter; and
 - a second set of undulations having a second outer diameter which is less than said first outer diameter, said first and said second sets of undulations being disposed one behind the other in a

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longitudinal extension of the pipe element, wherein said second set of undulations is interposed between neighboring pairs of said first set of undulations and said first set of undulations is interposed between neighboring pairs of said second set of undulations, wherein, in an unbent state of the pipe element, each one of said first set of undulations extends through a convex, substantially circular first arc of approximately 180° and joins a first straight segment extending substantially transverse to said longitudinal extension of the pipe element, said first straight segment joining a concave, substantially circular second arc of approximately 180° , said second arc joining a second straight segment extending substantially parallel to said first straight segment, said second straight segment joining onto a neighboring one of said second set of undulations, said neighboring one of said second set of undulations extending through a convex, substantially circular third arc of approximately 180° , said third arc joining a third straight segment extending substantially parallel to said first and said second straight segments, said third straight segment joining a concave, substantially circular fourth arc of approximately 180° , said fourth arc joining a fourth straight segment extending substantially parallel to said first, said second, and said third straight segments, said fourth straight segment joining a neighboring one of said first set of undulations having said first arc, wherein said first arc, said second arc, said third arc, and said fourth arc have substantially equal radii of curvature, wherein said first outer diameter of said first set of undulations exceeds said second outer diameter of said second set of undulations by 5 to

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20%, relative to said second outer diameter, the pipe element having a preset bending angle α which is always less than 140° .